

Date: Tuesday, 01/05/2007 2:24:01 PM
User: Linda Lacelle

Process Sheet

Split 07-05-16

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 31870-2
Estimate Number : 12709
P.O. Number : N/A
This Issue : 01/05/2007 S.O. No. : N/A
Prsh't Rev. : NC
First Issue : N/A Type : LARGE FAB ASSY
Previous Run : 31870
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 07-02-07 JLM
est rev B revB dwg EC

Drawing Name : GUIDE ASSEMBLY
Part Number : D3572041
Drawing Number : D3572 REV.B
Project Number : N/A
Drawing Revision : B
Material : N/A
Due Date : 13/05/2007

Qty: 60 Um: Each

Additional Product

Job Number:

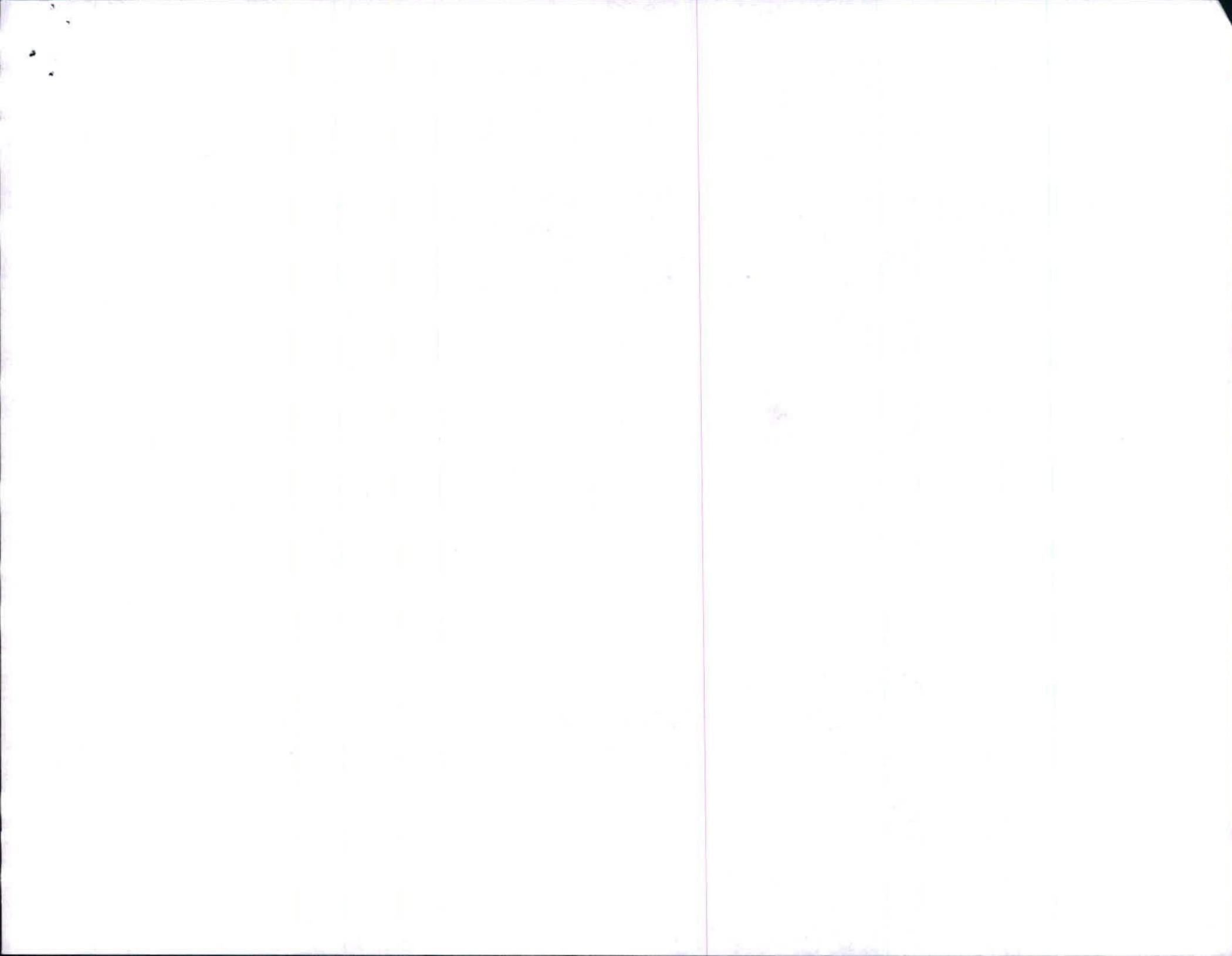


Seq. #:	Machine Or Operation:	Description:
1.0	D35723	GUIDE
		Comment: Qty.: 4.0000 Each(s)/Unit Total: 240.0000 Each(s) GUIDE Batch: 31912
2.0	D35727	CAP
		Comment: Qty.: 2.0000 Each(s)/Unit Total: 120.0000 Each(s) CAP Batch: 31914
3.0	D35726	BRACKET
		Comment: Qty.: 1.0000 Each(s)/Unit Total: 60.0000 Each(s) BRACKET Batch: 31913
4.0	M6061T6T1000W188	6061T6 TUBE 1.00 X .188W Comment: Qty.: 2.3405 ft(s)/Unit Total: 140.4270 ft(s) 6061-T6 Round Tube 1.00" x 0.188 wall Batch: 118101 07.05.16 X3
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut Tube D3572-1 as per Dwg D3572

118147
30.426
SUBSTITUTE 1"OD 6061-T6 ROD
16 07.05.14
X11
28/05/11



Tuesday, 01/05/2007 2:24:01 PM

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE ASSEMBLY

Job Number: 31870

Part Number: D3572041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Weld D3572-3 guides, D3572-7 caps and D3572-5 bracket as per Dwg D3572
A/R AL ROD Batch: M102756

PTO



3-Grind welds for end caps.

D 01-05-15 (14)

6.0

QC5

INSPECT WORK TO CURRENT STEP



J0705-15 (14)



Comment: INSPECT WORK TO CURRENT STEP

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

J07

07/05/15 (14)

(14)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 07/05/15

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

J0705-22 (2)

PTO

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

J0705-23

7/05/23

SL

(2)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



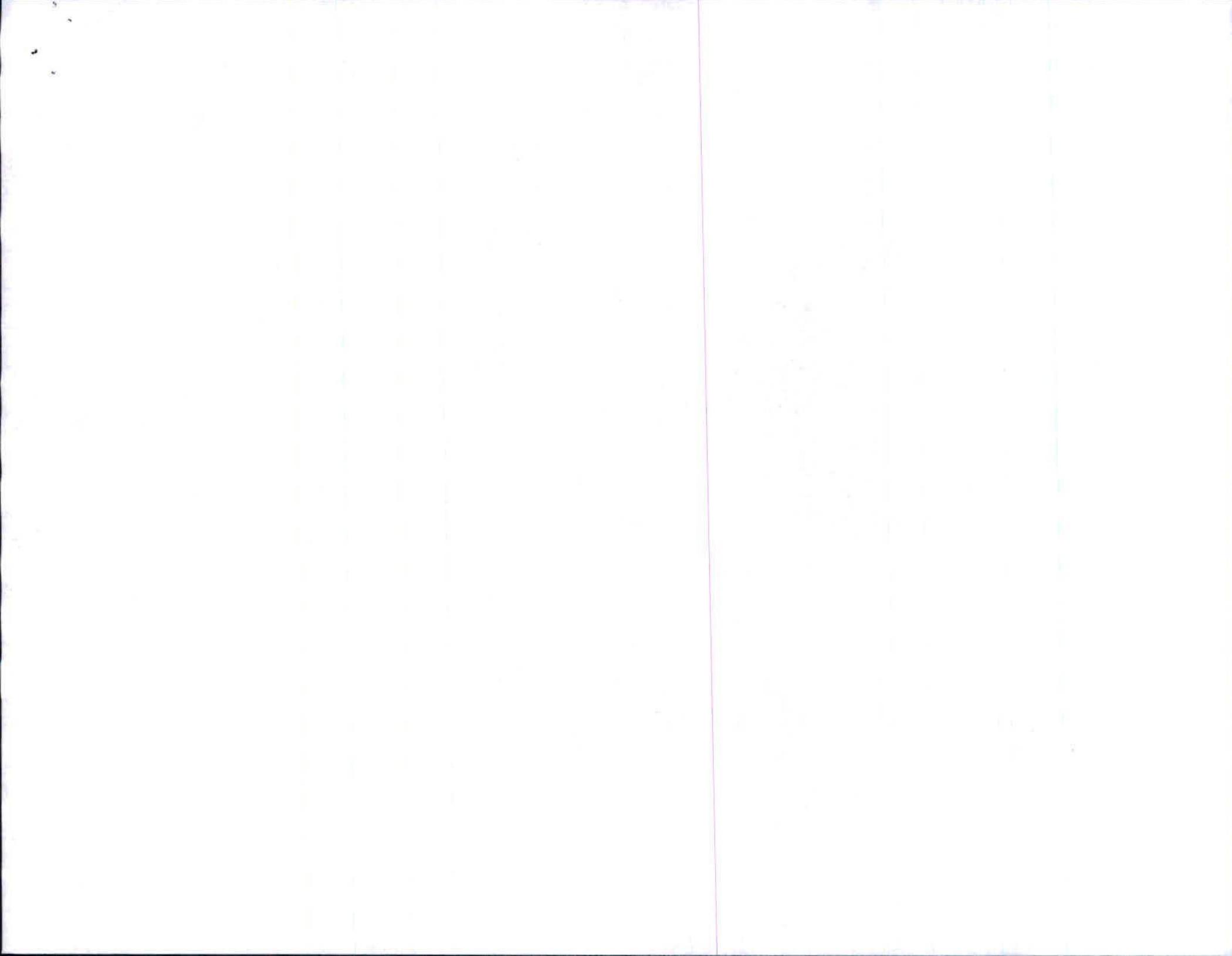
Comment: FINAL INSPECTION/W/O RELEASE

D0705/23

L B.0523

Job Completion:





W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod. Mgr	Approval QC Inspector
0705-16	10.0	Original was split for a qty of 8 on the B31870-1, and Qty 5 to remain on this w/o	J	0705-16	5	J 0705-16	J 0705-16

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/05/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date		
0705-15	5.0	B1 Redist. face between the D3572-3 Guidelines from 0.140" → 0.160". 3 parts.	J 051042	Scrap/destroy Qty 2 good remain.	J 0705-21 0705-22	J 051042	J 051042
0705-15	5.0	11 X D3572-1 tube material was missing. No more left in stock.	J 051042	Replace/Subst. tube using, 1" od 6061-T6 Solid Rod. → REQUIRED EXTRA HEATING AND WELD MATERIAL	J See orig. ing	J 051042	J 051042
0705-15	5.0	1 part took. used for testing, with Solid bar.	J 051042	test & scrap, no replace.	J 0705-15	J 0705-15	J 0705-15

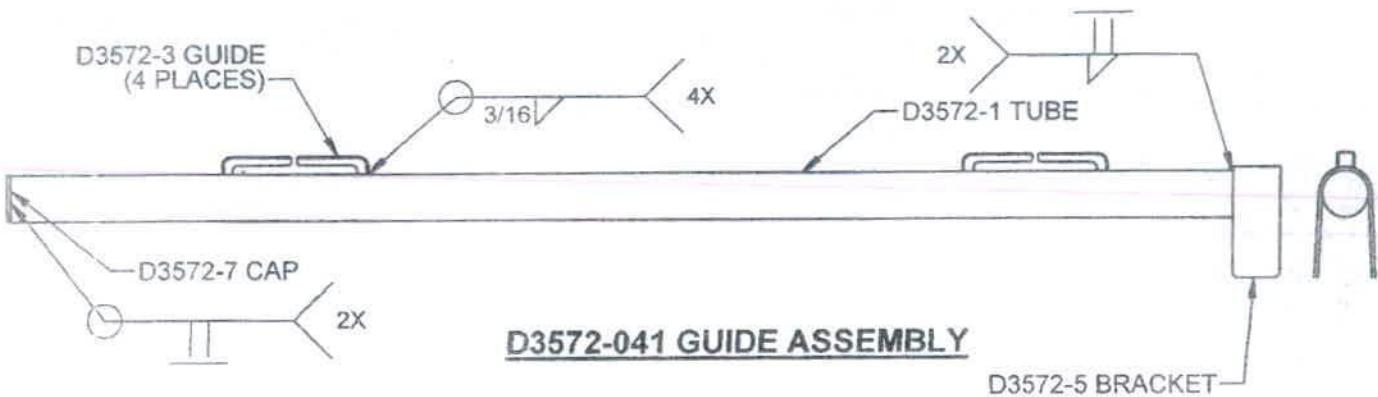
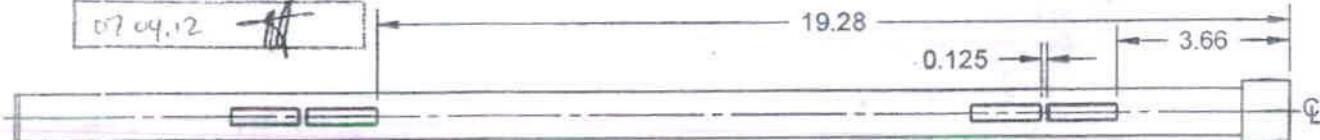
NOTE: Date & initial all entries



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D3572	REV. A	SHEET 1 OF 2
DATE 07.03.29		TITLE GUIDE ASSEMBLY	SCALE 1:4	
REV A	DATE 07.03.29	DESCRIPTION NEW ISSUE		

RELEASED

07.04.12 *✓*



D3572-041 NOTES:

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3572-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) WELD PER DART QSI 004

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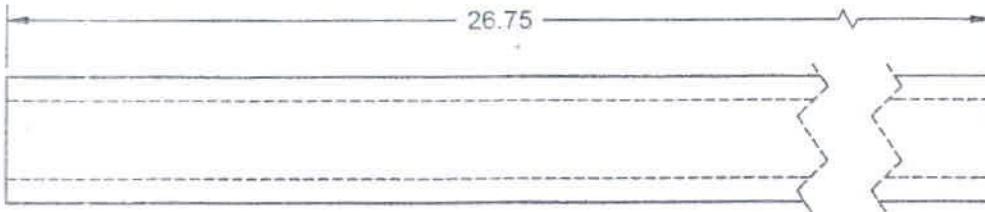
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WITHOUT NOTICE

WORK ORDER

NO 31810



D3572-1 TUBE

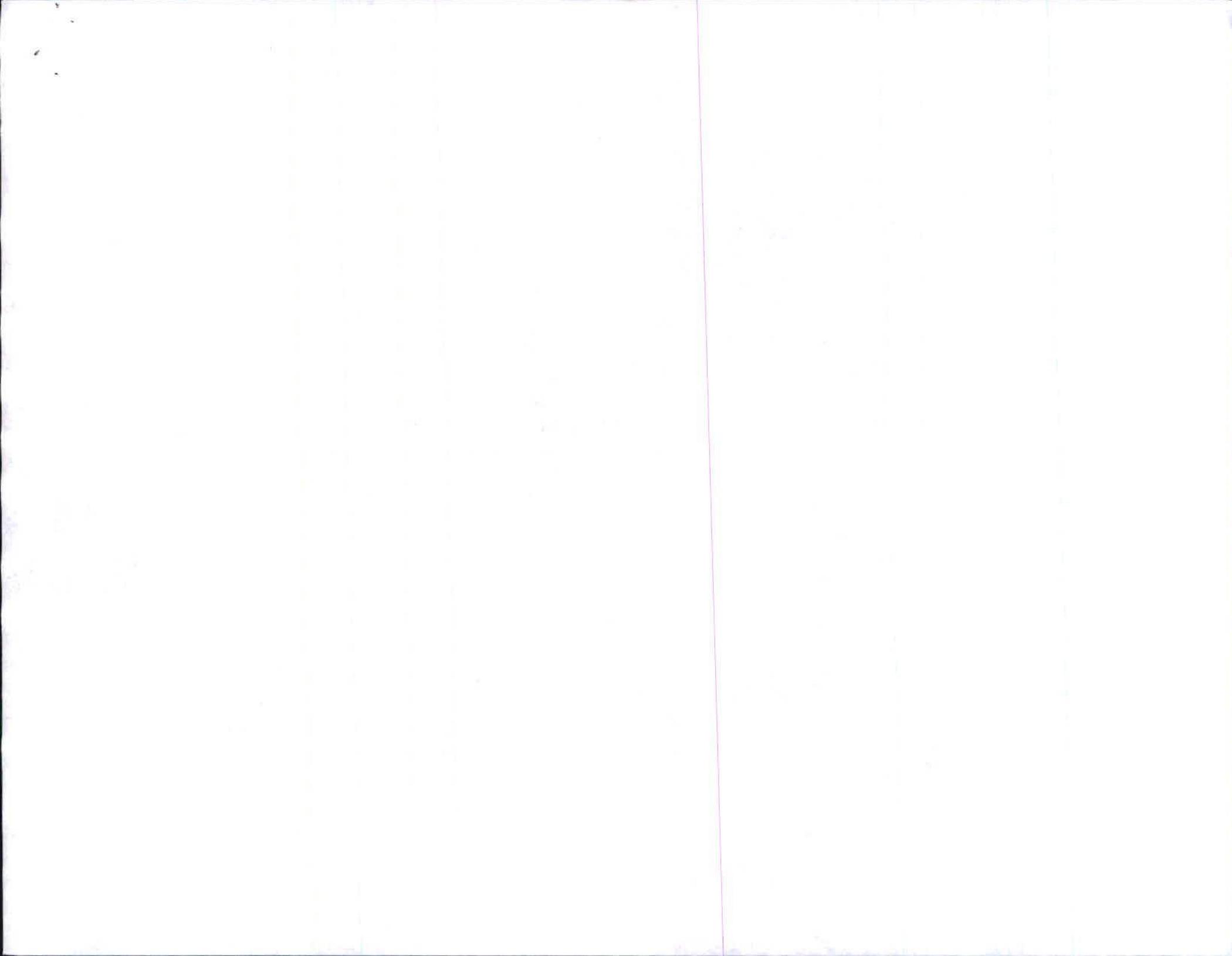
0.188 (REF) \varnothing 1.000 (REF)

D3572-1 NOTES:

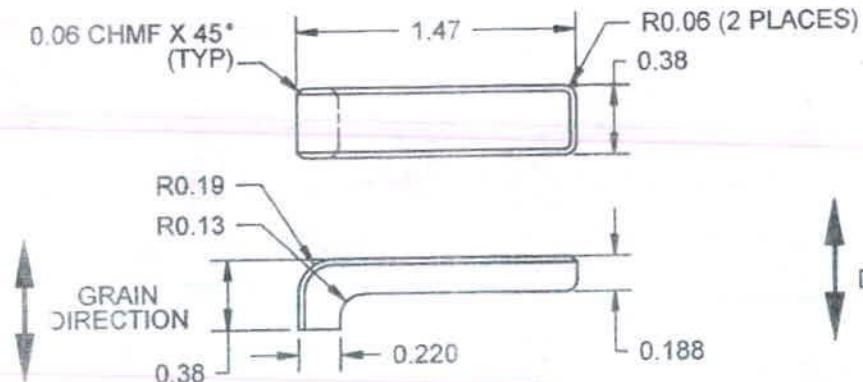
- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
(REF DART SPEC M6061T6T1.000W.188)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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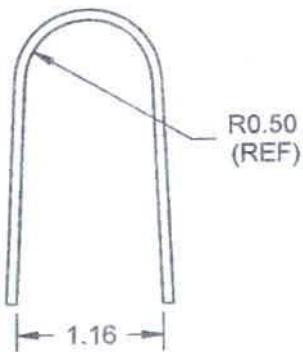
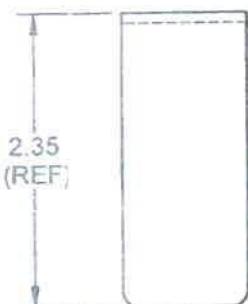
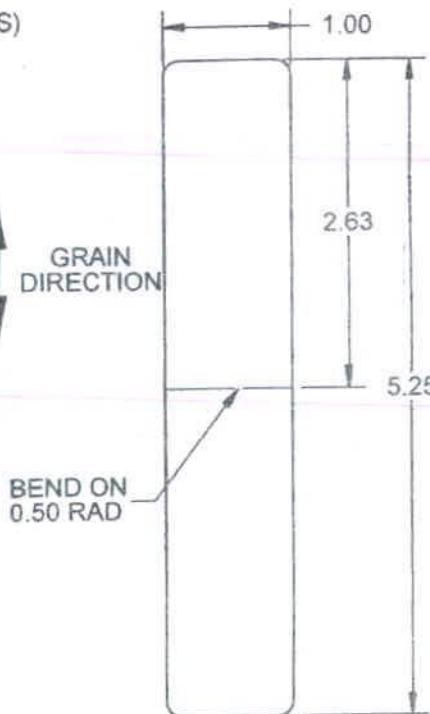
DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D3572	REV. A SHEET 2 OF 2
DATE 07.03.29	TITLE GUIDE ASSEMBLY	SCALE 2:3	



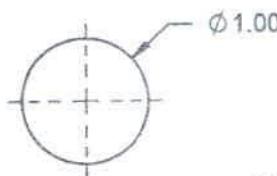
1) D3572-3 GUIDE

RELEASED

07.04.12 *✓*



2) D3572-5F FLAT PATTERN



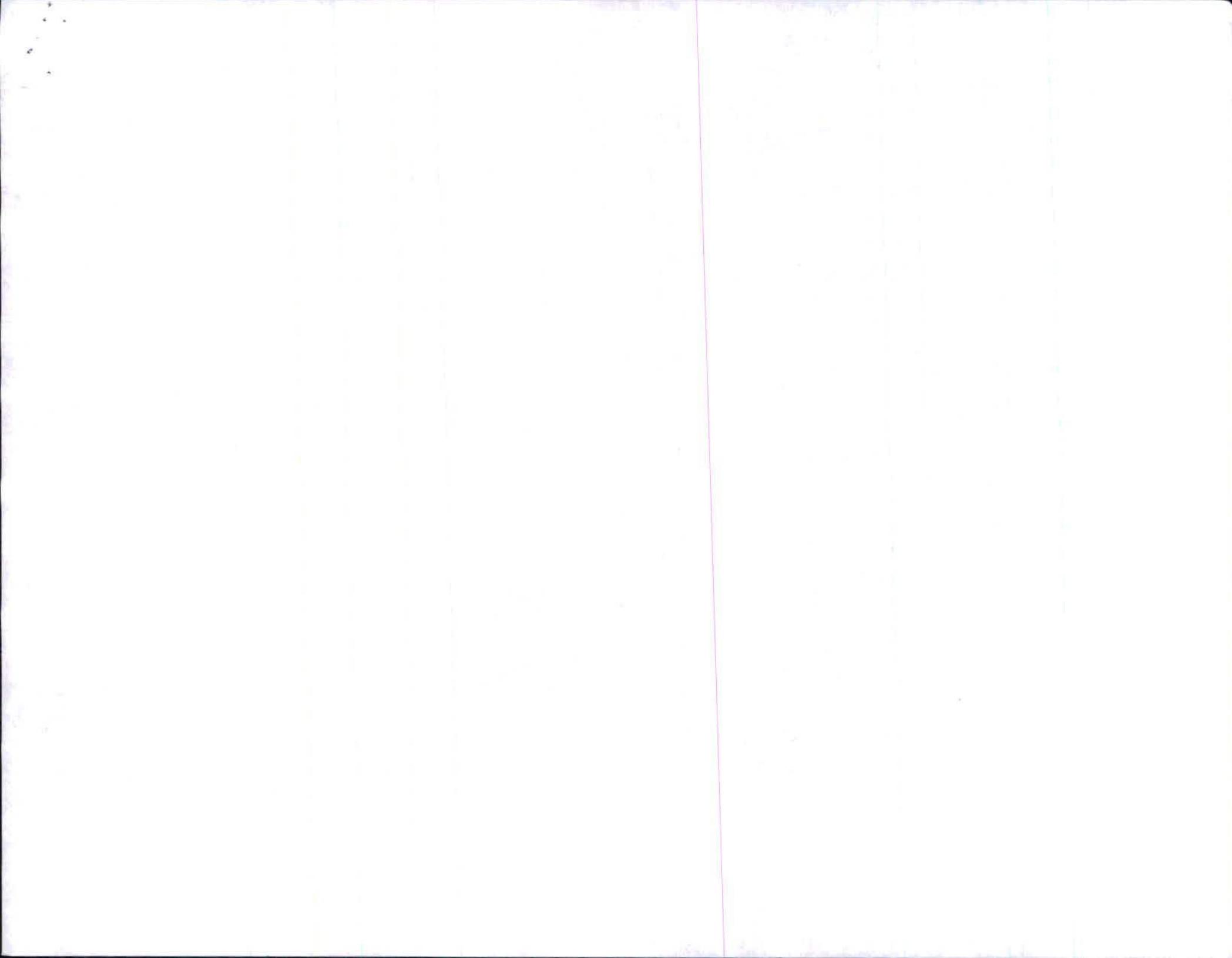
3) D3572-7 CAP

**D3572-5 BRACKET
(MAKE FROM D3572-5F)**

D3572-3/5/7 NOTES:

- 1) D3572-3 MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR PER QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6B)
- 2) D3572-5/7 MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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WORK ORDER
31870



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

